



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

DSK081

Job Sheet 178407



Part No: DSK081

Job Qty: 8 ea

Part Name: D2940-1 Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/31/18

Job Tracking No:

Due Date: 6/11/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP rev A. 08.03.13 new issue EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	6/11/18	6/11/18	0.00	0.00	Start Up Machining-4		<i>[Signature]</i> 18/06/06
100	Doosan	8 pcs	6/11/18	6/11/18	0.20	9.09	Doosan		<i>[Signature]</i> 18/06/06
110	QC	8 pcs	6/11/18	6/11/18	0.00	0.00	QC2 Machining-4		<i>[Signature]</i> 18/06/06
120	QC	8 pcs	6/11/18	6/11/18	0.00	0.00	QC8 Machining-4		<i>[Signature]</i> 18/06/06
130	Packaging	8 pcs	6/11/18	6/11/18	0.00	0.00	Packaging3-2		<i>[Signature]</i> 18/06/06
140	QC21-SA	8 Ea	6/11/18	6/11/18	0.00	0.00	QC21		<i>[Signature]</i> 18/06/06

Part Op 100 - Turn blank as per Folio FA079
Descriptions: 130 - LOCATION: MAT060

21
9-80

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6104-007	Round Billet, 17-4	8 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6104-007	8	16	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order:	
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3,213	3,216	3,213	3,216	3,215
B	4.946	4.966		4,959	4,956	4,956	4,956	4,954
C	0.718	0.738		0,728	0,728	0,728	0,728	0,728
D	0.090	0.110		0,100	0,100	0,100	0,100	0,100
E	3.564	3.584		3,576	3,575	3,575	3,575	3,576
F	0.022	0.042		0,032	0,032	0,032	0,032	0,032
G	3.444	3.464		3,454	3,454	3,455	3,455	3,456
H	0.112	0.132		0,118	0,115	0,115	0,115	0,116
I	2.170	2.190		2,180	2,180	2,180	2,180	2,180
J	4.451	4.471		4,464	4,464	4,464	4,464	4,464
K	0.413	0.433		0,423	0,423	0,423	0,423	0,423
L	0.913	0.933		0,923	0,923	0,923	0,923	0,923
M								
N								
O								
P								

Measured by: <i>msp</i>	Date: <i>18/04/05</i>
Audited by: <i>amk</i>	Date: <i>18/02/06</i>
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DART AEROSPACE LTD		Work Order:	
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FIRST ARTICLE INSPECTION DIMENSION SHEET

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G	3.444	3.464		3.454	3.455	3.454		
H	0.112	0.132		0.115	0.115	0.115		
I	2.170	2.190		2.180	2.180	2.180		
J	4.451	4.471		4.464	4.464	4.464		
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L	0.913	0.933		0.923	0.923	0.923		
M								
N								
O								
P								

Measured by: *[Signature]* Date: 18/04/05

Audited by: *[Signature]* Date: 18/04/06

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DQA: _____ Date: _____

WORK ORDER NON-

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved
Part No. _____	
NCR No. _____	

Date : _____	Step #: _____
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Description Work Order Deviation

DAK I
AEROSPACE

Container No: S078318

Part: DSK081

Job No: 178407

Serial No/Batch: S078318

Revision: _____

Inspector: _____

Exp Date: 06/06/2018

Instructions: _____

Date: 06/06/18

1270 Aberdeen Street
Newbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@daero.com
www.daerospace.com

QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY			
☐ Environment	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
☐ Design	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
☐ Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
☐ Equip/Tooling	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
☐ Handling/Pre	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
☐ Material	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
☐ Internal Transport	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
☐ Tribal Knowledge	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
☐ LOA	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
☐ Substation	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
☐ Past Expiry Date	☐ Manufacturing Process	OTHER :					
☐ Misidentified	☐ Past Due						